

Work Order ID 160097

Friday, April 21, 2017 7:44:16 AM

160097

Page 1

Item ID: D412-711-021 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Vertical Reference Door Modification LH
Start Date: 4/28/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/12/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: **DAS 21 9-89** Date: **APR 21 2017** Tooling: Date: Run Start ***NR1***
QC: **DAS 21 9-89** Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-711	L								

100 Document Control 0.00
100 DOCUMENT CONTROL
DC Memo 0.00
Doc.Control -USB or Paperwork Photocopy bluefiles and create labels per PPP D412-711-021 CHG002

DAS 27 9-89**APR 25 2017**

120 Pick Kit 0.00
120 Purchasing
Packaging Memo 0.00
Packaging

DAS 6 9-89**APR 25 2017****DAS 28 9-89**

130 QC4- 100% Inspect kits for completeness 0.00
130
QC Memo 0.03
Quality Control

DAS 27 9-89**APR 25 2017**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150						DAS 27 9-89			
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-711-021 Location: _____ PPP rev: _____								
						APR 25 2017			
160	QC21- Final Inspection - Work Order Release	0.00				DAS 21 9-89			
160								APR 26 2017	
QC	Memo	0.10							
Quality Control									

APR 25 2017

DAS
21
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/28/2017

Required Date: 5/12/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.04.07 new issue DD verf:EC
14.04.25 ECN14-548 DD verf:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4324-011 *D4324-011* Armrest Assembly		Manufactured	No			120	Each	0.0000	1	1			
D412-761-043 *D412-761-043* Modified Latch Mechanism, LH		Manufactured	No			120	Each	1.0000	1	1			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					FG020			1					
					159002			1					
D412-711-101 *D412-711-101* Replacement Vertical Reference Window		Manufactured	No			120	Each	1.0000	1	1			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					FG099			1					
					157437			1					
D3802-1-120 *D3802-1-120* Window Seal - 120"		Manufactured	No			120	Each	1.0000	1	1			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST639			1					
					160070			1					

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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/28/2017

Required Date: 5/12/2017

Start Qty: 1.00

Required Qty: 1.00

D4165-1 Manufactured No 120 Each 2.0000

D4165-1

Doubler

1 1

**

APR 25 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

ST236

2

153518

2

D4165-3 Manufactured No 120 Each 3.0000

D4165-3

Inner Door Panel

1 1

**

APR 25 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

ST235

3

156490

3

D4165-5 Manufactured No 120 Each 2.0000

D4165-5

Aft Rib

1 1

**

APR 25 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

ST236

2

153541

2

D4165-7 Manufactured No 120 Each 2.0000

D4165-7

Fwd Rib

1 1

**

APR 25 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

ST236

2

116604

2

D4165-9 Manufactured No 120 Each 2.0000

D4165-9

Angle

1 1

**

APR 25 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

ST237

2

153523

2

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Shop Packet Print

Page 2

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D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/28/2017

Required Date: 5/12/2017

Start Qty: 1.00

Required Qty: 1.00

D4165-11 Manufactured No 120 Each 3.0000

D4165-11

Door Cover Panel

**

APR 25 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

ST235

3

156380

3

D4207-1 Manufactured No 120 Each 3.0000

D4207-1

Window Retainer

**

APR 25 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

ST237

3

156413

3

D4207-3 Manufactured No 120 Each 3.0000

D4207-3

Instrument Window

**

APR 25 2017

DAS 6 9-89

Location

Loc Qty

Loc Code

ST237

3

156517

3

D4269-1 Manufactured No 120 Each 3.0000

D4269-1

Angle

**

APR 25 2017

DAS 6 9-89

Location

Loc Qty

Loc Code

ST089

3

143364

3

D4269-3 Manufactured No 120 Each 3.0000

D4269-3

Angle

**

APR 25 2017

DAS 6 9-89

Location

Loc Qty

Loc Code

ST089

3

156469

3

Friday, April 21, 2017 7:44:23 AM

Shop Packet Print

Page 3

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Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/28/2017

Required Date: 5/12/2017

Start Qty: 1.00

Required Qty: 1.00

AN3-3A Purchased No 120 Each 68.0000 22 22

AN3-3A

Bolt

**

Location

Loc Qty

Loc Code

ST350

68

m137061

18

m137320

50

AN3-4A Purchased No 120 Each 119.0000 20 20

AN3-4A

Bolt

**

Location

Loc Qty

Loc Code

ST350

119

m136579

119

AN3-6A Purchased No 120 Each 63.0000 26 26

AN3-6A

Bolt

**

Location

Loc Qty

Loc Code

ST350

63

153844

63

AN3-12A Purchased No 120 Each 236.0000 1 1

AN3-12A

Bolt

**

Location

Loc Qty

Loc Code

over003

206

153854

206

ST349

30

m135603

30

DQA: _____ Date: _____



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Required Date: 5/12/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

120

Each

1,410.000

92

92

NAS1149F0332P

Washer

**

APR 25 2017

DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

275

m133709

275

ST262

1135

m136835

8

m137075

1127

120

Each

135.0000

34

34

**

APR 25 2017

DAS 28 9-89

CR3242-4-2

Purchased

No

CR3242-4-2

RIVET

DAS
27
9-89

Location

Loc Qty

Loc Code

CCK003

100

m137061

100

ST318

35

m134962

35

120

Each

3,328.000

135

135

**

APR 25 2017

DAS 28 9-89

MS20426AD3-3

Purchased

No

MS20426AD3-3

RIVET

DAS
27
9-89

Location

Loc Qty

Loc Code

fg108

200

M134946

200

GA

880

M135274

880

ST312

2248

M135274

2248

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Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

Picklist Print

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Page 7

Work Order ID: 160097

160097

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/28/2017

Required Date: 5/12/2017

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-3

Purchased

No

120

Each

583.0000

140

140

MS20426AD4-3

Rivet

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

211

113064

211

ST312

372

m125807

372

**

APR 25 2017

DAS
28
9-89

MS20470AD3-3

Purchased

No

120

Each

6,032.000

25

25

MS20470AD3-3

RIVET, UNIVERSAL HEAD

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

787

1065

787

ST310

5245

16941

5245

**

APR 25 2017

DAS
28
9-89

MS20470AD4-3

Purchased

No

120

Each

1,945.000

90

90

MS20470AD4-3

Rivet, Universal Head

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

860

2193

87

m135536

773

ST310

1085

m135536

1085

**

APR 25 2017

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By _____					
				Lead hand / Supervisor Approval Verification _____					
				QC / QA Coordinator Approval _____					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____ _____ _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Page 8

Friday, April 21, 2017 7:44:23 AM

Work Order ID: 160097

160097

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/28/2017

Required Date: 5/12/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

120

Each

2,166.000

24

24

MS21042L3

Nut

**

LocationLoc QtyLoc Code

FP001

100

m135945

100

GA

168

m134360

102

M136665

66

OVER007

1300

m134360

0

M136665

300

m137321

1000

ST303

598

m137073

98

m137166

500

MS21059L3

Purchased

No

120

Each

120.0000

4

4

MS21059L3

Nut Plate

**

LocationLoc QtyLoc Code

GA

50

M137075

50

ST301

70

M137164

70

MS21069L3

Purchased

No

120

Each

96.0000

34

34

MS21069L3

ANCHOR NUT

**

LocationLoc QtyLoc Code

ST299

96

m136740

16

m136986

80

Friday, April 21, 2017 7:44:24 AM

Shop Packet Print

Page 8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									

Picklist Print

Friday, April 21, 2017 7:44:24 AM

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Work Order ID: 160097

160097

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/28/2017

Required Date: 5/12/2017

Start Qty: 1.00

Required Qty: 1.00

MS21069L08

Purchased

No

120

Each

434.0000

8

8

MS21069L08

ANCHOR NUT

DAS
27
9-89

Location

Loc Qty

Loc Code

ST299

434

123522

434

MS21071L3

Purchased

No

120

Each

51.0000

3

3

MS21071L3

ANCHOR NUT

DAS
27
9-89

Location

Loc Qty

Loc Code

ST299

51

125654

51

MS21071L08

Purchased

No

120

Each

149.0000

1

1

MS21071L08

ANCHOR NUT

DAS
27
9-89

Location

Loc Qty

Loc Code

ST299

149

102587

49

103447

100

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
Past Expiry Date ☐ Misidentified ☐ OTHER : _____									

QTY -011	QTY -013	QTY -015	QTY -017	QTY -019	QTY -021	QTY -041	PART NUMBER	DESCRIPTION
					22	22	AN3-3A	BOLT
					20	20	AN3-4A	BOLT
					26	26	AN3-6A	BOLT
					1	1	AN3-12A	BOLT
					92	92	NAS1149F0332P	WASHER (OR AN960-10L)
					34	34	CR3242-4-2	RIVET
					135	135	MS20426AD3-3	RIVET
					140	140	MS20426AD4-3	RIVET
					25	25	MS20470AD3-3	RIVET
					90	90	MS20470AD4-3	RIVET
					24	24	MS21042L3	NUT
					4	4	MS21059L3	NUT PLATE
					34	34	MS21069L3	NUT PLATE
					8	8	MS21069L08	NUT PLATE
					3	3	MS21071L3	NUT PLATE
					1	1	MS21071L08	NUT PLATE
						1	204-030-853-125	LH COPILOT DOOR (204-030-853-137/-155)
1							D412-711-111	WIRING HARNESS, 212/412
B ₁							B ^D D4268-043	INSTRUMENT PANEL, 212/412 (REPLACES EA20469-15-412)
	1						D205-711-113	WIRING HARNESS, 205
	B ₁						B ^D D4268-041	INSTRUMENT PANEL, 205 (REPLACES EA20469-15-205)
		1					D204-711-115	WIRING HARNESS, 204
		B ₁					B ^E EA20469-15-204	INSTRUMENT PANEL, 204
			1				D214-711-117	WIRING HARNESS, 214
			B ₁				B ^E EA20469-15-214	INSTRUMENT PANEL, 214
				1			D212-711-119	WIRING HARNESS, EAGLE SINGLE
				B ₁			B ^D D4268-047	INSTRUMENT PANEL, EAGLE SINGLE

- (A) IF CUSTOMER PREFERS TO SUPPLY AND MODIFY THEIR OWN DOOR, D412-711-021 SHOULD BE SUPPLIED IN LIEU OF D412-711-041
(B) INSTRUMENT PANEL INCLUDED WITH HARNESS ABOVE

NOTES

1) WIRING HARNESSES:

For Bell 204/205/210 Wiring Harnesses, use drawing D2046904.
For Bell 212 Wiring Harnesses, use drawing D2046903*.
For Bell 214 Wiring Harnesses, use drawing D214-761-511.
For Bell 412 Wiring Harnesses, use drawing D412-711-901.
For Bell 212 modified per SH07-28/SR02831NY use D212-761-224
or D212-761-225 depending on aircraft s/n.

* Despite the note on the drawing, D2046903 is applicable to all 212 aircraft serial numbers

Wiring Harnesses will vary depending on aircraft s/n.

2) D412-711-101 REPLACEMENT WINDOW:

To increase downward viewing clarity, it is acceptable to cut a small section from the replacement window on its downward side per Figure 1 of this document. The cutout can be a maximum of 9.00" wide x 17.00" long (229mm x 432mm), measured along the profile of the replacement window. The corners of the cutout must have a minimum radius of 2" (50mm). The cutout should be located at least 1.0" (25mm) from the flange. The actual shape of the cutout can vary as desired, as long as the overall dimensions are within the specified limits. See Figure 1 for reference.

3) D412-711-043 SNAP VENT KIT:

It is acceptable to install a total of up to 2X D3932-1 Snap Vents (available from Dart) onto the D412-711-101 Replacement Window to provide ventilation into the cabin. Refer to Figure 1 for acceptable locations and size of cutouts.

4) It is acceptable to use MS21042L3 nuts to install the window in lieu of anchor nuts shown on D2046901.

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. L
MFG. APPR.	N/A	D412-711	SHEET 3 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	VERTICAL REFERENCE DOOR	NTS
DATE	17.01.20	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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REFERENCE ONLY

QTY -011	QTY -013	QTY -015	QTY -017	QTY -019	QTY -021	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X								D412-711-011	VERTICAL REFERENCE DOOR INSTALLATION, 212/412
	X							D205-711-013	VERTICAL REFERENCE DOOR INSTALLATION, 205/210
		X						D204-711-015	VERTICAL REFERENCE DOOR INSTALLATION, 204
			X					D214-711-017	VERTICAL REFERENCE DOOR INSTALLATION, 214
				X				D212-711-019	VERTICAL REFERENCE DOOR EAGLE SINGLE
					X			D412-711-021	VERTICAL REFERENCE DOOR KIT
^1	^1	^1	^1	^1		X		D412-711-041	VERTICAL REFERENCE DOOR ASSEMBLY
							X	D412-711-043	SNAP VENT KIT
					1	1		D412-761-043	MODIFIED LATCH MECHANISM KIT, LH (REPLACES EA20469-23/-24/-25)
					1	1		D412-711-101	REPLACEMENT WINDOW (REPLACES EAGLE P/N EB212-100L / EA20469-3)
					1	1		D3802-1-120	RUBBER STRIP
							2	D3932-1	SNAP VENT
					1	1		D4165-1	DOUBLER
					1	1		D4165-3	DOOR INNER SKIN (REPLACES EA20469-18)
					1	1		* D4165-5	AFT RIB (REPLACES EA20469-34)
					1	1		** D4165-7	FWD RIB (REPLACES EA20469-31)
					1	1		D4165-9	ANGLE (REPLACES EA20469-17)
					1	1		D4165-11	DOOR COVER PANEL (REPLACES EA20469-21)
					1	1		D4207-1	WINDOW RETAINER (REPLACES EA20469 -14)
					1	1		D4207-3	WINDOW (REPLACES EA20469-13)
					1	1		* D4269-1	ANGLE (REPLACES EA20469-33)
					1	1		** D4269-3	ANGLE (REPLACES EA20469-30)
					1	1		** D4269-5	ANGLE (REPLACES EA20469-29)
					1	1		* D4269-7	ANGLE (REPLACES EA20469-32)
					1	1		D4324-011	ARM REST ASSEMBLY (REPLACES EA20469-16)
					1	1		D4327-1	ANGLE (REPLACES EA20469-11)
					1	1		D4327-3	ANGLE (REPLACES EA20469-07)
					2	2		D4385-1	PLACARD

* PART OF EA20469-10 REAR RIB ASSEMBLY

** PART OF EA20469-12 FWD RIB ASSEMBLY

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	ML	DRAWING NO.	REV. L
MFG. APPR.	N/A	D412-711	SHEET 2 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	VERTICAL REFERENCE DOOR	NTS
DATE	17.01.20	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	